

purpose of binding the sliding point in place. Evidently, when the screw and wedge are forced in, the sliding point is expanded, and the friction against the jig wall *D* is so great that it can withstand a very heavy pressure without moving. Pin *E* prevents the sliding point from slipping through the hole and into the jig, when loosened, and also makes it more convenient to get hold of. In the accompanying table are given the dimensions most commonly used for sliding points and binding shoes and wedges.

Special Types of Adjustable Stops. — Adjustable stops are used to a greater extent in milling fixtures than in drill jigs, but

Dimensions of Sliding Points and
Shoes or Binders



Screws

A					A		
B	2H	2}4	2M	2H	B	He	^{9*2}
C	to 3	to 3	to 3	to 3	Me	C	

the principles employed are the same. The examples shown in connection with the following description of adjustable stops have been applied to milling

fixtures, and, in some cases, to drill jigs. In Fig. 15 is shown the simplest type of adjustable stop, provided with a helical spring beneath the plunger, to press it against the work. The objection to this type of stop is that the plunger *A* will slip back under the pressure of the clamps or cutting tools upon the work. There is also danger of the milled flat on the plunger clogging with dirt, so that the stop will not work properly. Considerable time is, therefore, lost in using jigs or fixtures with this type of stop. The method of clamping the plunger is also slow, as it is necessary to use a wrench in tightening or loosening the set-screw *B*. In Fig. 16 is shown an adjustable stop which is an improvement over that shown in Fig. 15. The flat on the side of plunger *A* is milled at a slight